

Work Order ID 81959

March-21-12 1:43:07 PM

81959

Page 1

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 21/03/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3537 | Rev C |

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr
 if necessary

304 .063

1B12-4-7

15m 120405 50

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

1B12-4-7

15m 120405 50

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

5/12/2012

count
20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | NC BRAKE | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1 | | | | | | | | |
| 140 | Large Fab | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | Qty Description Batch A/R 2059B Hardcoat 1-21333 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary | | | | | | | | |
| 150 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SB 12/04/09

50

50

12-05-01
JBL

cat
50

50

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 QC5- Inspect part completeness to step on W/O 0.00

160

QC

Memo

0.00

Sortesta

cat
100

Quality Control

170 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

11:10
3200 F
11:40

SOX *mf*
12/05/01

180 QC3- Inspect Part Finish 0.00

180

QC

Memo

0.00

Quality Control

SOX *12/05/01*

| W/O: | | WORK ORDER CHANGES | | | | | |
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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 | Identify as per dwg & Stock Location: F-P2 | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 200 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

50 X **✓** **M-K**
12/5/11 **MF**
12-05-01

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NOTE: Date & initial all entries

Picklist Print

March-21-12 1:43:10 PM

Page 1

Work Order ID: 81959

81959

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA | | Purchased | No | | | 100 | sf | 441.9860 | 0.106 | 5.578947 | | | |

M304S16GA

304/316 Sheet .063

**

1812-4-7

50

Location

Loc Qty

Loc Code

MAT020

441.986

119653

17.35

120866

73.5

120877

159.136

121070

192

121070

50

5m 120405

121070

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NOTE: Date & initial all entries

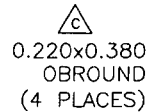
| W/O: | | WORK ORDER CHANGES | | | | | |
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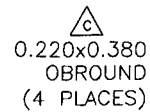
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



50-70



(MADE FROM D3537-1F)



(MADE FROM D3537-3F)



(MADE FROM D3537-1F)



1) MATERIAL: AISI 304 / 316 SS SHEET

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

| | | |
|---------------------|----------------------------------|--|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN CB | DRAWN BY PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED A | APPROVED A | DRAWING NO. D3537 REV. C SHEET 1 OF 1 |
| DATE 07.04.13 | TITLE WEARPAD SCALE 1:2 | |

RETURN TO

ENGINEERING

CONTROLLED

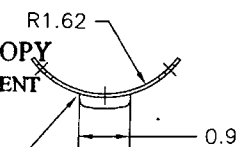
SUBJECT TO AMENDMENT

— WITHOUT NOTICE

WORK ORDER

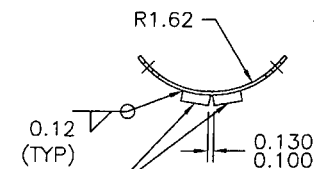
25 81959

17/03/21

R1.62 \neg 

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

OK @ 11.11.15

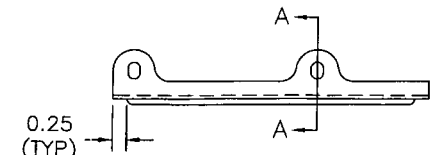
R1.62 \neg 

D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

THESE
RELEASED
07-05-08 PM

(MADE FROM D3537-3F)

(MADE FROM D3537-3F)



~~UNDER REVIEW~~

11.10.21

Change

| W/O: | | WORK ORDER CHANGES | | | | | |
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